

Date: Monday, 02/03/2009 9:03:01 AM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PILOT/CO-PILOT STEP, RH (FOLDING)
Job Number : 46120	
Estimate Number : 10824	
P.O. Number :	Part Number : D412630032
This Issue : 02/03/2009 S.O. No. :	Drawing Number : IIN D412-630
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : <i>XM</i> <i>09/03/02</i>
Previous Run : 46119	Material :
Written By :	Due Date : 16/03/2009 Qty: 4 Um: Each
Checked & Approved By : <i>JUD 09.03.02</i>	
Comment : EST. REV. A 05.11.21 NEW ISSUE EC EST. REV. B 05.12.19 updated pick list EC EST. REV. C 07.11.12 ecn 1019, nochg EC verifiedby:DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



JUD 09/03/06



Comment: DOCUMENT CONTROL

Photocopy D412-630 bluefile & type labels per PPP412-630-032 CHG001

*CHG002**09/04/09*

2.0	D3463042	Step Weldment Assembly
-----	----------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3463-042	Step weldment	<i>46123</i>

09/03/31 *(re)*

3.0	D3443043	Strut Weldment Assembly
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-043	Strut ass'y	<i>B 46130 x2</i>

B46123 *(2)*

4.0	D3443041	Strut Weldment Assembly
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-041	Strut ass'y	<i>46128 x4</i>

09/04/14 x4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34439

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3443-9	Pin	B 46131 *

JS 09/03/31 (vu)

6.0

AN4CH3

SS Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN4CH3	BOLT	M111261
A/R MS20995c41e Lockwire			1101537

JS 09/03/31 (vu)

7.0

D34547

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3454-7	Bushing	B 46132

JS 09/03/31 (vu)

8.0

AN3104

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN310-4	Nut	M111660

JS 09/03/31 (vu)

9.0

MS24665227

COTTER PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS24665-227	COTTER PIN	M11674

JS 09/03/31 (vu)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D34551

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

2

D3455-1

Spacer

B416133

8809103/31 (x4)

11.0

D34651

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D3465-1

Washer

B416192

8809103/31 (x4)

12.0

AN3107

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

AN310-7

Nut

M103286

8809103/31 (x4)

13.0

MS24665302

Cotter Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

MS24665-302

COTTER PIN

M106763

8809103/31 (x4)

14.0

AN4C14

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

AN4C14

BOLT

M110552

8809103/31 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.17

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

JS 09/04/06 (X4)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

****ensure tension to retract step is 11 to 18 lbs ****

Test fit on aircraft in Eng. lab.

JS 09/04/06 (X4 R12)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

18.0

D34541

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

S (FV)

Qty	Part Number	Description	Batch
1	D3454-1	Bushing	<i>46135</i>

JS 09/04/06 (X4)

19.0

D34543

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

S (FV)

Qty	Part Number	Description	Batch
2	D3454-3	Bushing	<i>46136</i>

JS 09/04/06 (X4)

20.0

D34545

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

S (FV)

Qty	Part Number	Description	Batch
2	D3454-5	Bushing	<i>46137</i>

JS 09/04/06 (X4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 46120

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D34551

Spacer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

84

D3455-1

Spacer

B416133

SS 09/04/06 (x4)

22.0

D34553

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

2

D3455-3

Spacer

46139

SS 09/04/06 (x4)

23.0

D3462042

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D3462-042

Bracket ass'y

46141 x 2

SS 09/04/06 (x4)

24.0

AN3104

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

AN310-4

Nut

1110600

SS 09/04/06 (x4)

25.0

AN3105

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

2

AN310-5

Nut

M116552

SS 09/04/06 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 46120

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN3C5A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
3	AN3-C5A	Bolt	M110910

S (40)

8809104/06 (40)

27.0

AN44C12

eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN44-C12	Eyebolt	M110342 x3 M110847 x1

S (40)

8809104/06 (40)

28.0

AN4C15

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN4C15	BOLT	M110155 x2 M111303

S (40)

8809104/06 (40)

29.0

AN5C11

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN5C11	BOLT	M1103248

S (40)

8809104/06 (40)

30.0

AN5C15

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN5C15	BOLT	M110552

S (40)

8809104/06 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 46120

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

AN960C10

WASHER



Comment: Qty.: 7.0000 EACH(s)/Unit Total : 28.0000 EACH(s)

Pick:

Qty Part Number Description Batch
7 AN960C10 Washer

M109165

JS 09/04/06 (x4)

32.0

AN960C516

WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 AN960C516 Washer

M162842

JS 09/04/06 (x4)

33.0

MS210433

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch
3 MS21043-3 Nut

M116562

JS 09/04/06 (x4)

34.0

MS24665227

COTTER PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 MS24665-227 COTTER PIN

M1169174

JS 09/04/06 (x4)

35.0

MS24665229

COTTER PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 MS24665-229 COTTER PIN

M1169174

JS 09/04/06 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 46120

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

NAS1515H5

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

S *4*

Qty

Part Number

Description

Batch

1

NAS1515H5

Washer

M69430

S *09/04/06*

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

S *09/04/09* *4* *RTU*

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-032

Location:

PPP Rev:

31
B

9/4/9

S

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/13

Job Completion



MF
09-04-09

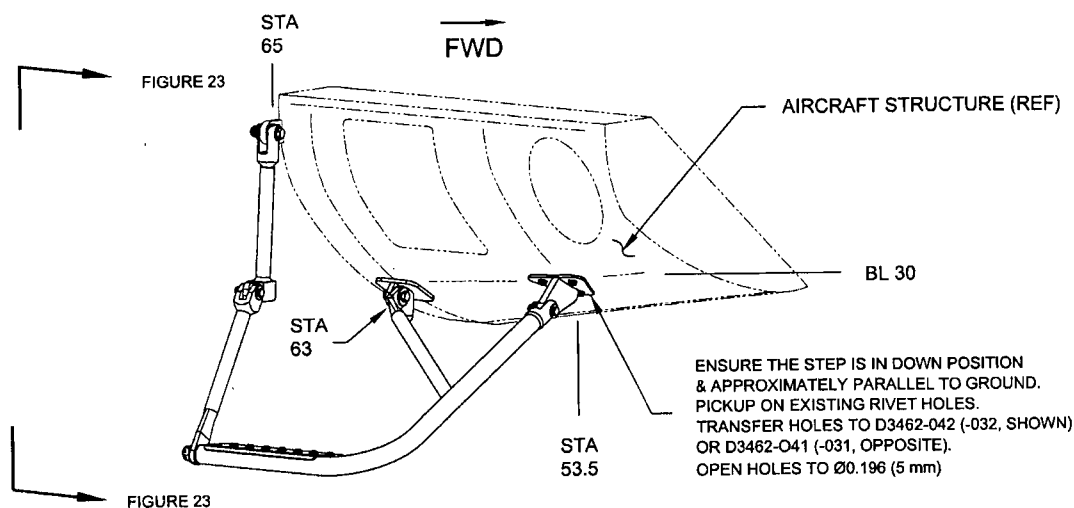
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

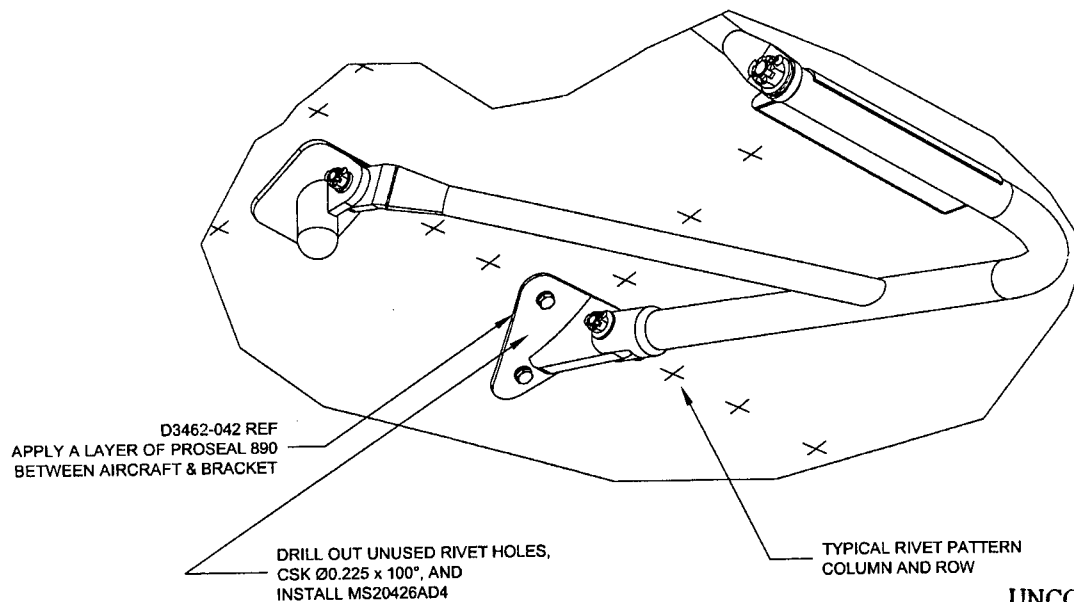
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D412-630-031/-032 Pilot/Co-Pilot Folding-Step Installation

**FIGURE 21 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown),
D412-630-031 LH (Opposite)**



**FIGURE 22 – Detail View D3462-042 Bracket Assembly (-032 Installation, Shown),
D3462-041, (-031 Installation Opposite)**

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 46120

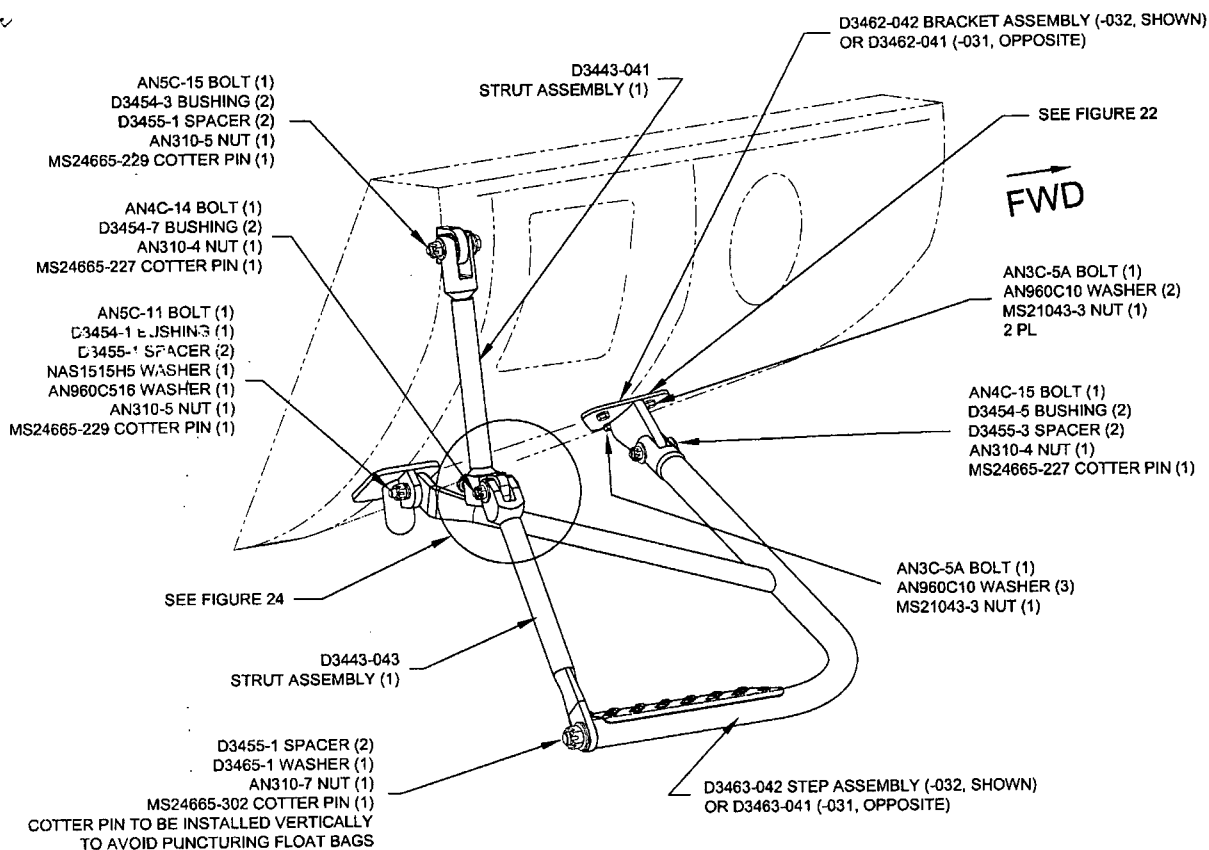


FIGURE 23 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

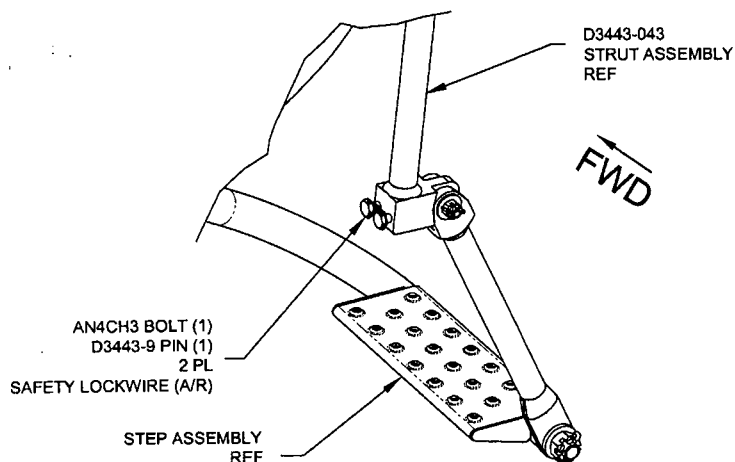


FIGURE 24 – Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

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